



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

U/R

OK 4/14/18

RUSH

D5489-3

Job Sheet 175898



Part No: D5489-3 Job Qty: 5 ea
Part Name: Wearplate

Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 4/11/18 Job Tracking No:
Due Date: 4/19/18 Created By: Michelle Gagnon-Donovan
Type: SOLD Description:
Note: IPP REV:A 17.11.03 AS PER DWG REV:A DD VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/18/18	4/18/18	0.00	0.00	Start Up Waterjet		JC 4/18/18
100	Waterjet	5 pcs	4/18/18	4/18/18	0.00	1.93	Waterjet1		SL 4/18/18
110	QC	5 pcs	4/18/18	4/18/18	0.00	0.00	QC2 Waterjet-4		SL 4/18/18
120	QC	5 pcs	4/18/18	4/18/18	0.00	0.00	QC8-6		38
130	Brake NC	5 pcs	4/18/18	4/18/18	0.00	0.90	Brake NC 1		DAE 4/18/18
140	QC	5 pcs	4/18/18	4/18/18	0.00	0.00	QC5		38
150	HandFinish	5 pcs	4/19/18	4/19/18	0.00	0.25	HandFinish4		JND 4/18/18
160	QC	5 pcs	4/19/18	4/19/18	0.00	0.00	QC3		11 APR 27 2018
170	Packaging	5 pcs	4/19/18	4/19/18	0.00	0.00	Packaging3-2	54602	APR 30 2018
180	QC21-SA	5 Ea	4/19/18	4/19/18	0.00	0.00	QC21		21 APR 30 2018

Part Op 100 - 1-Cut as per Dwg (D5489-3) Dwg Rev: 9 Prog Rev: 9 2-Deburr if necessary
Descriptions: 150 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R
ROCKGUARD BATCH: 138854
170 - LOCATION : FP002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	14.5000 sf (2.9 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	15	203	0

Part Specifications

Specifications could not be found.

Plex 4/11/18 2:05 PM Dart.Gagnon.Michelle

P.T.O. 2018

DQA:

18 Jan 2019

Date:

QA Closed:

Date:

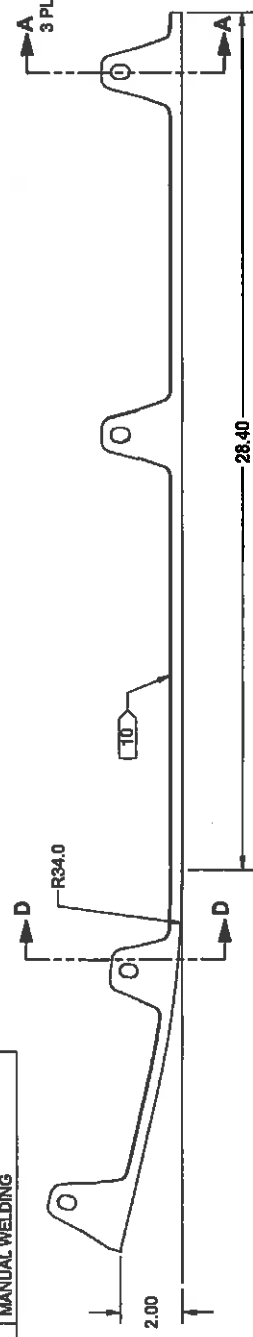
WORK ORDER NON-CONFORMANCE / UPDATE



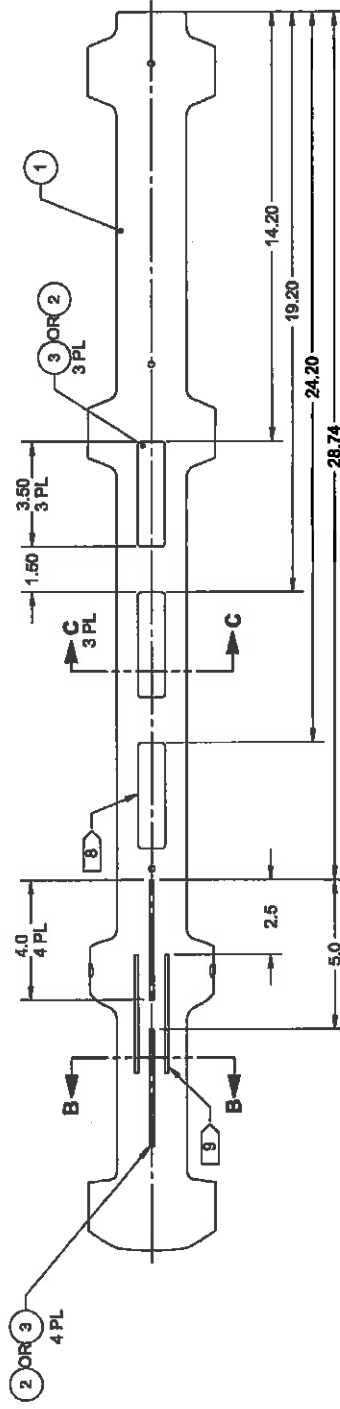
Work Order update only

Work Order: 175898		AGAINST DEPARTMENT/PROCESS	
Part No. D5489-3		Cross tube	
NCR No. 19-7166		Small Fab	
Date: 18/04/12		Finishing	
Step #: 100		Composite	
Description Work Order Deviation		Supplier	
DISPOSITION		QTY Effective: 5	
Rework ☒		Water Jet ☐	
Scrap ☐		Prod. Eng. Coord. ☐	
Use-as-is ☐		Rec/Store/Packaging ☐	
Suspected Unapproved ☐		Engineering Quality ☒	
Other ☐		Other ☐	
Disposition		MRB (QS1042) Approval	
Acceptable. No change to bent shape. Deviate flat pattern dims per attached referenced drawing		DAS 12 18/4/12	
Completed By		Lead hand / Supervisor Approval Verification	
DAS 40 18/05/17		DAS 9 18-05-17	
QC / QA Coordinator Approval		QC / QA Coordinator Approval	
DAS 9 18-05-17		DAS 9 18-05-17	
FAULT CATEGORY		Positioned Wrong	
Temperature/Cure		Outside Dimensions	
Set-up		Over/Under tolerance	
BOM/Route		Part Incorrect	
Broken/Damage/Defect		Part Lost/Missing	
Inspection Incomplete/Unqualified		Part Moved	
Contamination		Drawing Finish	
Countersink		Misread	
Cut Too Short		Turning Sequence	
Instructions Incomplete/Unclear			
Drill Holes			
Pressure/Forced Bending			
Centre Not Concentric			
Cracks			
Crimp/Kink/Ripple/Wave			
Cuffs			
Crushing			
Heat Treat			
Wave/Twist in Tube			
Marks/Chatter			
OTHER:			
Root Cause			
No Re-verification			
Operator			
Offset/Setup			
Supplier			
Training			
Use for Testing			
Poor Information			
Rushing			
Product Improvement			
Process Improvement			
Manufacturing Process			
Past Due			
Environment			
Design			
Doc/Data			
Equip/Tooling			
Handling/Pre			
Material			
Internal Transport			
Tribal Knowledge			
LOA			
Substation			
Past Expiry Date			
Misidentified			

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5489-041	WEARPLATE ASSEMBLY
1	1	D5489-1	WEARPLATE
2	AR	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	AR	2059B	HARDCOAT SURFACING MANUAL WELDING



D5489-1 WEARPLATE
(MAKE FROM D5489-1F)



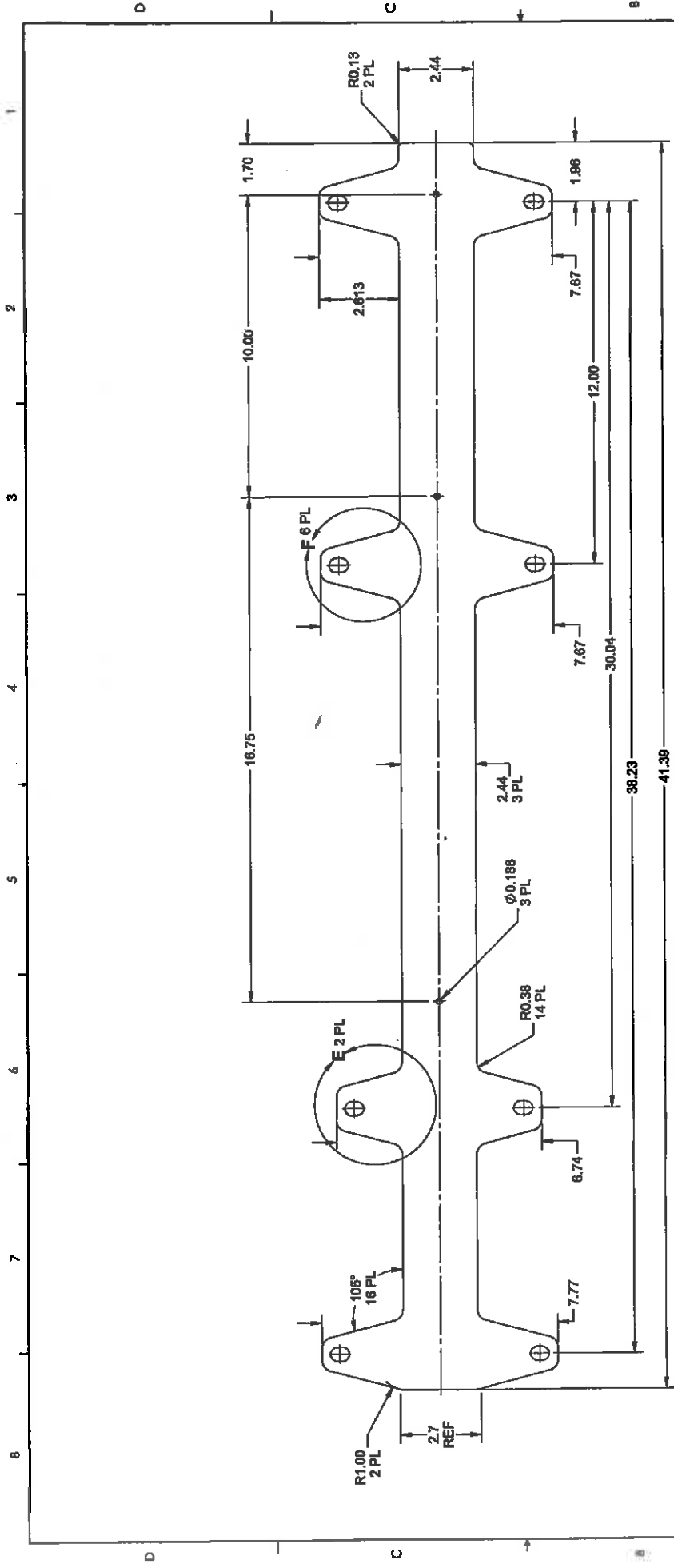
D5489-041 WEARPLATE ASSEMBLY

UNDER REVIEW
URF17-729 NO

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK: SHARP EDGES: N/A
 - 6) IDENTIFICATION: PER DART QSI 044 6.1
 - 7) WEIGHT: 2.5 lbs
 - 8) WELDING: BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.17 TO 0.20 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) WELDING: BUILD UP HARD SURFACING 0.08 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.08 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

RELEASED
R 2017-10-31
ECN 17-728

REV.	NEW ISSUE	DESCRIPTION	SAD	BY	DATE
DESIGN	DRAWN	NO	NO	NO	NO
CHECKED	APPROVED	DD	DD	DD	DD
DATE	17.08.10	17.08.10	17.08.10	17.08.10	17.08.10
DART AEROSPACE LTD					
HAWKESBURY, ONTARIO, CANADA					
DRAWING NO. D5489					
REV. A					
SHEET 1 OF 7					
SCALE					
TITLE WEARPLATE					
DATE 17.08.10					
CONTRACT NO. DART BY DART AEROSPACE LTD					
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED IN THE CONTRACT. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.					



D5489-1F WEARPLATE
(FLAT PATTERN)

UNDER REVIEW
URF17-729 NO

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5058 OR AMS 5513 (304),
OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

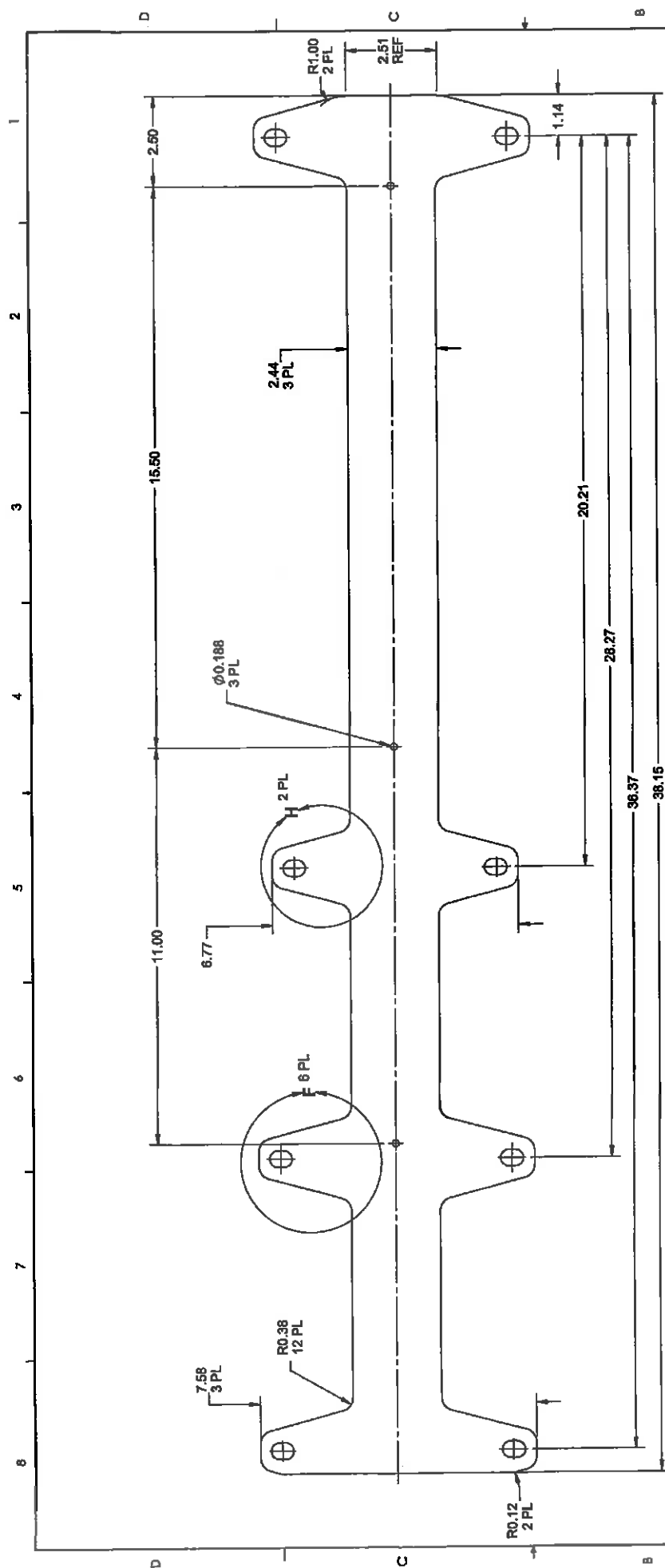
6) IDENTIFICATION: NONE

7) WEIGHT: 1.8 lbs

RELEASED
2017-10-31

DESIGN	SAD	NO	DART AEROSPACE LTD
DRAWN	NO	AJS	HAVERSBURY, ONTARIO, CANADA
CHECKED	AJS	DD	DRAWING NO. D5489
MFG. APPR.	WM	DS	REV. A SHEET 2 OF 7
APPROVED	DS	DS	TITLE WEARPLATE
DE APPR.	DS	DS	SCALE NTS
DATE	17.08.10		

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D5488-5F WEARPLATE
(FLAT PATTERN)

UNDER REVIEW
URF17-729 NO

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5058 OR AMS 5613 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.7 lbs

RELEASED
2017-10-31

DESIGN	SAD	NO	DART AEROSPACE LTD
DRAWN			HAWKSBURY, ONTARIO, CANADA
CHECKED	AJS		DRAWING NO.
MFG. APPR.	DD		D5488
APPROVED	WM		REV. A
DE APPR.	DS		SHEET 5 OF 7
DATE	17.08.10		SCALE
			NTS
			TITLE
			WEARPLATE

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